

इंटरनेट

मानक

### Disclosure to Promote the Right To Information

Whereas the Parliament of India has set out to provide a practical regime of right to information for citizens to secure access to information under the control of public authorities, in order to promote transparency and accountability in the working of every public authority, and whereas the attached publication of the Bureau of Indian Standards is of particular interest to the public, particularly disadvantaged communities and those engaged in the pursuit of education and knowledge, the attached public safety standard is made available to promote the timely dissemination of this information in an accurate manner to the public.

“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 10886 (1984): Carpenters' Vice [PGD 6: Earth, Metal And Wood Working Hand Tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”



BLANK PAGE





*Indian Standard*  
**SPECIFICATION FOR  
CARPENTERS' VICE**

**1. Scope** — Covers the requirements of carpenters' vice, having fixed base for mounting on work tables.

**2. Dimensions**

**2.1** The dimensions of carpenters' vice shall be as given in Table 1.

**2.2** Tolerances on untoleranced dimensions, shall be in accordance with IS : 2102 (Part 1) - 1980 'General tolerances for dimensions and form and position : Part 1 General tolerances for linear and angular dimensions (second revision)'.

**2.3** The illustrations are diagrammatic only and are not intended to give details of design.

**3. Material** — The recommended materials for different components of the carpenters' vice are given below. Other materials may be used by agreement between the manufacturer and the purchaser.

<i>Component</i>	<i>Material</i>
Body	Grey cast iron conforming to grade FG 200 of IS : 210-1978 'Grey iron casting (third revision)'
Screw spindle, handle and supporting bars	Steel conforming to Fe410 of IS : 1570 (Part 1)-1978 'Schedule for wrought steels : Part 1 Steels specified by tensile or yield properties'.
Jaw plate	Grey cast iron conforming to grade FG200 of IS : 210-1978 or steel conforming to Fe410 of IS : 1570 (Part 1)-1978

**4. Hardness** — The hardness of the jaw plates shall be 35 to 45 HRC ( $\approx$  330 — 430HV).

**5. Manufacture**

**5.1 Body and Jaw Plate** — The body and jaw plate of the carpenter's vice shall be of sound construction. At least 4 holes shall be provided on the body for mounting the base on work tables. The body and plate shall be accurately machined. The holes in the jaw shall be accurately drilled and tapped.

**5.2 Supporting Bars** — Both the supporting bars, on which the body slides, shall be properly machined.

**5.3 Screw Spindle** — The screw spindle shall have trapezoidal threads which shall be accurately cut. It shall be so designed that it does not come out during normal use at the maximum opening of the jaw plates.

**5.4 Handle** — The handle shall be straight and shall slide freely in the hole provided at the end of the screw spindle. It shall not come out of the hole during use. The sharp corners on the handle shall be rounded off.

**6. Workmanship and Finish** — The casting shall be sound and free from foundry defects like blow holes, pits, scales, scabs and other imperfections. The unmachined portion shall be dressed smooth. All components shall be free from cracks, rust, seams, flaws and other manufacturing defects. The screw spindle shall move freely in the body without any play or stiffness.

**7. Designation** — A carpenters vice of 150 mm nominal size shall be designated as follows:  
Carpenters' Vice 150 IS : 10886

**8. Preservative Treatment** — The vice shall be painted on all nonworking surfaces including underside of the base. The working surfaces shall be covered with a suitable rust-preventing material.

**9. Marking** — The vices shall be marked with the nominal size, the manufacturer's name, initials or trade-mark.

**9.1 ISI Certification Marking** — Details available with the Indian Standards Institution.

Adopted 12 March 1984

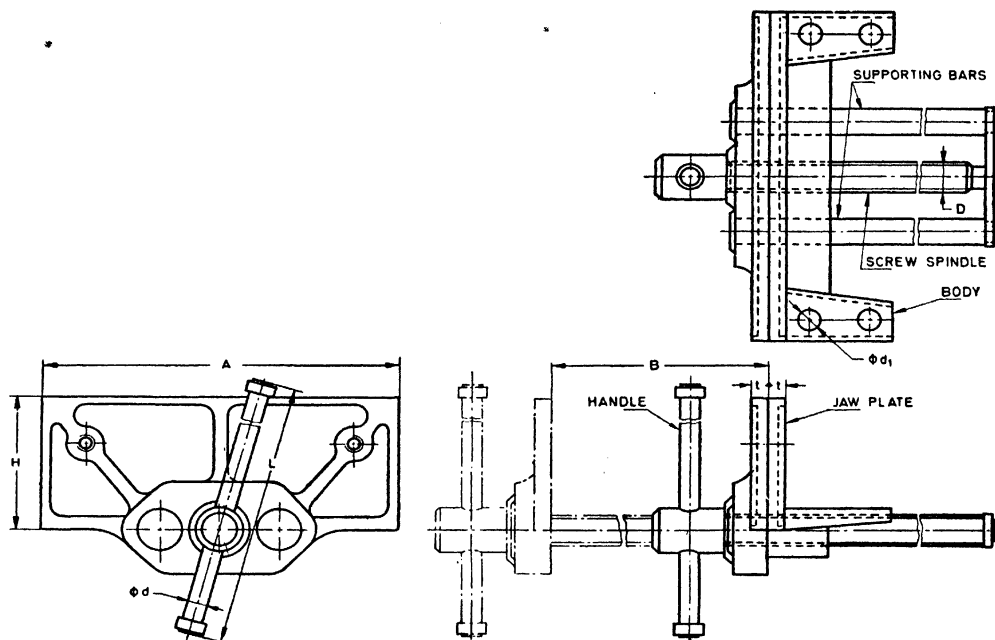
© June, 1984 ISI

Gr 1

TABLE 1 DIMENSIONS FOR CARPENTERS' VICE

( Clause 2.1 )

All dimensions in millimetres.



Nominal Size (Width of Jaws) A	B	L	d	$d_1$	$D^*$	t	H	Mass kg
150	90	145	8	10	Tr14 × 3	7	60	1.750
175	210	200	12	13	Tr20 × 4	12	75	7.0
225	350	250	14	15	Tr22 × 5	18	100	16.0

**Note** — The mass specified is recommendatory only and has been given for the guidance of manufacturers and users.

\*Trapezoidal threads as per IS : 7008 (Part 2) - 1973 'ISO metric trapezoidal screw threads: Part 3 Basic dimensions for design profiles.'

**10. Sampling** — Unless otherwise agreed to between the supplier and the purchaser, the sampling inspection procedure given in IS : 2500 (Part 1) - 1973 'Sampling inspection tables: Part 1 Inspection by attributes and by count of defects' shall be followed. The inspection level and AQL for various characteristics shall be as given in 10.1 and 10.2.

**10.1** For dimensions, and workmanship and finish, single sampling plan with inspection level II and AQL of 4 percent given in Table 1 and 2 of IS : 2500 (Part 1) - 1973 shall be adopted.

**10.2** For hardness characteristics, single sampling plan with inspection level I and AQL 2.5 percent given in Table 1 and 2 of IS : 2500 (Part 1) - 1973 shall be adopted.

### EXPLANATORY NOTE

The carpenters' vices are generally used to hold the wooden blocks in pattern shop or in wood-working carpentry shops.

This specification is based on the details provided by the leading manufacturers of the product.

**AMENDMENT NO. 1 JUNE 1996**  
**TO**  
**IS 10886 : 1984 SPECIFICATION FOR**  
**CARPENTERS' VICE**

( *Page 1, clause 2.2* ) — Substitute 'IS 2102 ( Part 1 ) : 1993 General tolerances : Part 1 Tolerances for linear and angular dimensions without individual tolerance indications ( *third revision* )' for 'IS : 2102 ( Part 1 ) - 1980 General tolerances for dimensions and form and position : Part 1 General tolerances for linear and angular dimensions ( *second revision* )'.

( *Page 2, Table 1, foot-note with '\*\*' mark* ) — Substitute the following for the existing:

\*\*Trapezoidal threads as per IS 7008 ( Part 3 ) : 1988 ISO metric trapezoidal screw threads : Part 3 Basic dimensions ( *first revision* ).'

( *Page 2, clause 10* ) — Substitute 'IS 2500 ( Part 1 ) : 1992 Sampling inspection procedures : Part 1 Attribute sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection ( *second revision* )' for 'IS : 2500 ( Part 1 ) - 1973 Sampling inspection tables : Part 1 Inspection by attributes and by count of defects'.

( *Page 2, clauses 10.1 and 10.2, line 2* ) — Substitute 'Tables I and II-A of IS 2500 ( Part 1 ) : 1992' for 'Tables 1 and 2 of IS : 2500 ( Part 1 ) - 1973'.

( PE 07 )